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D2666-1

Job Sheet 192707



Part No: D2666-1

Job Qty: 1 pcs

Part Name: Saddle, LH, Fwd, Aft, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/1/19

Job Tracking No:**Due Date: 4/30/19**

Created By: Jason Leroux

Type: Stock

Description:

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	1 pcs	4/30/19		0.00	0.91	HAAS - 1	SBL	
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	Conventional Mill - 1 - B4B	1 pcs	4/30/19		0.00	1.12	Conventional Mill - 1 - B4B	SBL	
							Conventional Mill - 2 - B4B		
120	QC 2	1 pcs	4/30/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
QC 2 - 50									
QC 2 - 51									
QC 2 - 52									



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Container No: S168193



Part: D2666-1

Job No: 192707

Serial No/Batch: S168193

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/01/19

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					QC 2 - 56	
					QC 2 - 57	SBL 19/04/01
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 8 - 12	
130 QC 8	1 pcs	4/30/19	0.00 0.00	QC 8 - 14		
				QC 8 - 17		
				QC 8 - 20		
				QC 8 - 25		
				QC 8 - 3		
				QC 8 - 32		
				QC 8 - 33		
				QC 8 - 35		
				QC 8 - 39		
				QC 8 - 4		
				QC 8 - 44		
				QC 8 - 45		
				QC 8 - 49		
				QC 8 - 58		
				QC 8 - 8		
				QC 8 - 9		
				QC 8 - 68		
				QC 8 - 67		
				QC 8 - 1 (A)		
				QC 8 - 47		
QC 8 - 40						
QC 8 - 52						
QC 8 - 23						
140 Handfinish - 1-1 Chemical-B4B	1 pcs	4/30/19	0.00 0.05	Handfinish - 1 - 1 - B4B		
				Handfinish - 1 - 2 - B4B		
				Handfinish - 1 - 3 - B4B		
				Handfinish - 1 - 4 - B4B		
				Handfinish - 1 - 5 - B4B		
				Handfinish - 1 - 6 - B4B		
				Handfinish - 1 - 7 - B4B		
				Handfinish - 1 - 8 - B4B		
				Handfinish - 1 - 9 - B4B		
				Handfinish - 1 - 10 - B4B		
				Handfinish - 1 - 11 - B4B		
				Handfinish - 1 - 12 - B4B		
				Handfinish - 1 - 13 - B4B		
				Handfinish - 1 - 14 - B4B		
				Handfinish - 1 - 15 - B4B		
				Handfinish - 1 - 16 - B4B		
				Handfinish - 1 - 17 - B4B		
				Handfinish - 1 - 18 - B4B		
				Handfinish - 1 - 19 - B4B		
				Handfinish - 1 - 20 - B4B		
				Handfinish - 1 - 21 - B4B		
				Handfinish - 1 - 22 - B4B		
150 Powdercoat - 1 White Gl(A)-B4B	1 pcs	4/30/19	0.00 0.04	Powdercoat - 1 - B4B		
				Powdercoat - 2 - B4B		
				Powdercoat - 3 - B4B		
				Powdercoat - 4 - B4B		
					Plex 4/1/19 8:35 AM dart.leroux.jasor	

160 QC 3	1 pcs	4/30/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
170 Packaging 3-1 - Stock - B4B	1 pcs	4/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	1 pcs	4/30/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - HAAS CNC Vertical Machine - Program batch number.

Descriptions: 110 - Manufacture as per dwg - Machine Keyway and Inspect per attached dimension sheet
120 - QC2- Inspect parts off machine FAI/FAIB
130 - QC8- Inspect parts - second check
140 - Chemical Conversion Coat per QSI005 4.1
150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) - START TIME: _____
160 - QC3- Inspect Part Finish
170 - Identify as per dwg & Stock Location: _____
180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-001	Saddle Billet	1 pcs (1 ea)	100-HAAS 4 Axis	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-001	1	25	0

Part Specifications

Specifications could not be found.

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DQA: _____ Date: 19/04/01

Date:

DQA:

QA Closed: Date:

QA Clc

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order: 192707		Part No. D266-1		NCR No.	
Date: 19/04/01		Step #: 100		QTY Effective: 1	
Description Work Order Deviation		Disposition		MRB (Q51042) Approval	
pieces have move in the jig		Scrappe and replace		Completed By DAS 57 19/04/01 9-89 Lead hand / Supervisor Approval Verification DAS 68 APR 04 2019	
Root Cause		Fault Category		Positioned Wrong	
Environment		Temperature/Cure		Outside Dimensions	
Design		Set-up		Over/Under tolerance	
Doc/Data		BOM/Route		Part Incorrect	
Equip/Tooling		Broken/Damage/Defect		Part Lost/Missing	
Handling/Pre		Inspection Incomplete/Unqualified		Part Moved	
Material		Contamination		Drawing	
Internal Transport		Countersink		Finish	
Tribal Knowledge		Cut Too Short		Misread	
LOA		Instructions Incomplete/Unclear		Turning Sequence	
Substation		Drill Holes			
Past Expiry Date		OTHER :			
Misidentified					